

Work Order ID 145015

145015

Page 1

April 29, 2016 9:51:09 AM

Item ID: D2891-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support 2.25
 Start Date: 5/2/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 5/16/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: SL Date: 20160429 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2891	B								
100	HAAS CNC VERTICAL MACHINING #1	0.07							
100									
HAAS 1	Memo	8.60							
HAAS CNC vertical machine #1	1-Machine as per Folio FA046 2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.20							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.40							
Quality Control									

20 SL 16-5-4

20 SL 16-5-4

20 SL 16-05-04
 DAS
 20
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																				
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<i>Region at top center of support under tolerance by 0.007" to in thickness (0.083). Due to excessive buffing</i>		<i>Acceptable. Checked fit with a/c bracket.</i>		QC / QA Coordinator Approval																																																																																																				
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="4" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td style="width:12.5%;">Environment ☐</td> <td style="width:12.5%;">☐</td> <td style="width:12.5%;">No Re-verification ☐</td> <td style="width:12.5%;"></td> <td style="width:12.5%;">Pressure/Forced ☐</td> <td style="width:12.5%;">☐</td> <td style="width:12.5%;">Temperature/Cure ☐</td> <td style="width:12.5%;">☐</td> </tr> <tr> <td>Design ☐</td> <td>☐</td> <td>Operator ☐</td> <td></td> <td>Bending ☐</td> <td>☐</td> <td>Set-up ☐</td> <td>☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>☐</td> <td>Offset/Setup ☐</td> <td></td> <td>Centre Not Concentric ☐</td> <td>☐</td> <td>BOM/Route ☐</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>☐</td> <td>Supplier ☐</td> <td></td> <td>Cracks ☐</td> <td>☐</td> <td>Broken/Damage/Defect ☐</td> <td>☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>☐</td> <td>Training ☐</td> <td></td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>☐</td> </tr> <tr> <td>Material ☐</td> <td>☐</td> <td>Use for Testing ☐</td> <td></td> <td>Cuffs ☐</td> <td>☐</td> <td>Contamination ☐</td> <td>☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>☐</td> <td>Poor Information ☐</td> <td></td> <td>Crushing ☐</td> <td>☐</td> <td>Countersink ☐</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>☐</td> <td>Rushing ☐</td> <td></td> <td>Heat Treat ☐</td> <td>☐</td> <td>Cut Too Short ☐</td> <td>☐</td> </tr> <tr> <td>LOA ☐</td> <td>☐</td> <td>Product Improvement ☐</td> <td></td> <td>Wave/Twist in Tube ☐</td> <td>☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>☐</td> </tr> <tr> <td>Substation ☐</td> <td>☐</td> <td>Process Improvement ☐</td> <td></td> <td>Marks/Chatter ☐</td> <td>☐</td> <td>Drill Holes ☐</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>☐</td> <td>Manufacturing Process ☐</td> <td></td> <td colspan="4" rowspan="2" style="vertical-align: top;">OTHER : _____</td> </tr> <tr> <td>Misidentified ☐</td> <td>☐</td> <td>Past Due ☐</td> <td></td> </tr> </tbody> </table>					Root Cause				FAULT CATEGORY				Environment ☐	☐	No Re-verification ☐		Pressure/Forced ☐	☐	Temperature/Cure ☐	☐	Design ☐	☐	Operator ☐		Bending ☐	☐	Set-up ☐	☐	Doc/Data ☐	☐	Offset/Setup ☐		Centre Not Concentric ☐	☐	BOM/Route ☐	☐	Equip/Tooling ☐	☐	Supplier ☐		Cracks ☐	☐	Broken/Damage/Defect ☐	☐	Handling/Pre ☐	☐	Training ☐		Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐	Material ☐	☐	Use for Testing ☐		Cuffs ☐	☐	Contamination ☐	☐	Internal Transport ☐	☐	Poor Information ☐		Crushing ☐	☐	Countersink ☐	☐	Tribal Knowledge ☐	☐	Rushing ☐		Heat Treat ☐	☐	Cut Too Short ☐	☐	LOA ☐	☐	Product Improvement ☐		Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Substation ☐	☐	Process Improvement ☐		Marks/Chatter ☐	☐	Drill Holes ☐	☐	Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____				Misidentified ☐	☐	Past Due ☐	
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 41 9-89
130						20			16-5-5
HandFXtube	Memo	0.60							
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time.	132391							
140	QC3- Inspect Part Finish	0.00							DAS 38 9-89
140						20			MAY 06 2016
QC	Memo	0.20							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							69-6 9 9-89
170						20			MAY 06 2016
Packaging	Memo	0.20							
Packaging	LOCATION: LG052								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	2.00							
Quality Control									

20160506

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

April 29, 2016 9:51:13 AM

Page 1

Work Order ID: 145015

145015

Parent Item: D2891-1

D2891-1

Parent Item Name: Support 2.25

Start Date: 5/2/2016

Required Date: 5/16/2016

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C02.11.26Added P/OKJ

IPP D 08.03.19 Re-format EC verified: DD

IPP Rev:E

11.08.04 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DSK076

Manufactured

No

110

Each

15.0000

0.5

10

DSK076

D2891-1 Turning Detail

Location

Loc Qty

Loc Code

MAT060

15

141324

15

10

mf 16/05/02

NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ± 0.010) UNLESS OTHERWISE NOTED

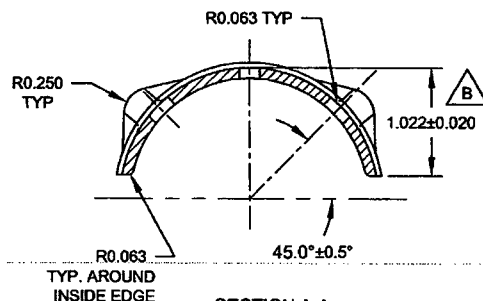
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

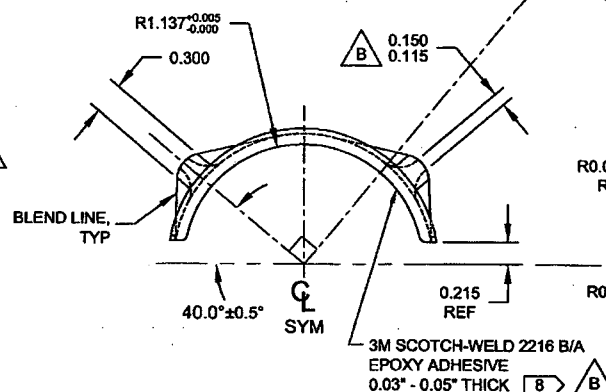
6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.38 lb

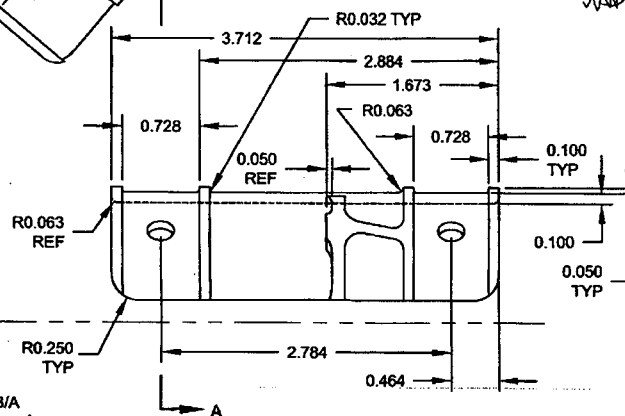
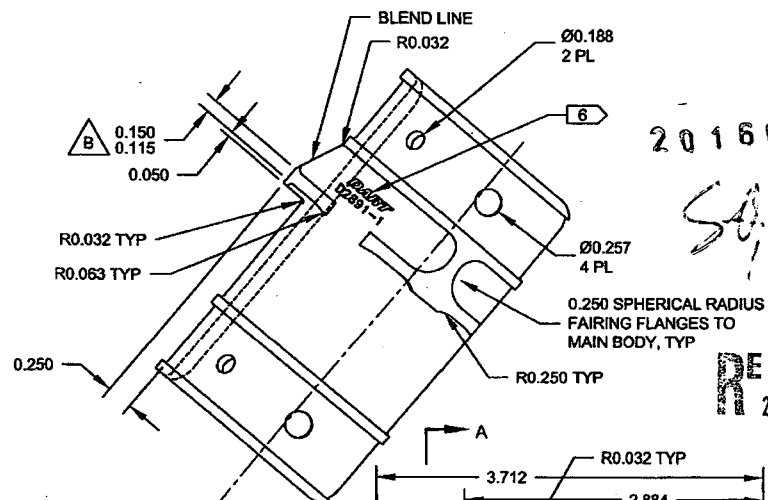
8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



SECTION A-A



D2891-1 SUPPORT



20160429

RELEASED
2011-07-28

B	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZN D4-1,B4-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2891
TITLE Ø2.250 SUPPORT
REV. B
SHEET 1 OF 1
SCALE NTS

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DART AEROSPACE LTD		Work Order:	145015
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.252	.252	.252	.252	.252
AC	0.115	0.150		.125	.125	.125	.125	.125
AD	0.040	0.060		.051	.051	.050	.050	.050
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.138	.138	.138	.138	.138
AI	0.454	0.474		.464	.464	.463	.463	.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.038	1.036	1.036	1.032	1.036
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.257	.257	.257	.257	.257
AO	1.663	1.683		1.675	1.675	1.677	1.677	1.672
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by:	JL	Date:	16-5-3
Audited by:	DAS 20 16-05-04 9-89	Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	145015
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	5/10
HAAS Section								
AA	0.188	0.193		-189	-189	-189	-189	-189
AB	0.240	0.260		-252	-252	-252	-251	-251
AC	0.115	0.150		-125	-125	-125	-125	-125
AD	0.040	0.060		-050	-050	-050	-058	-053
AE	0.010	0.020		-015	-015	-015	-015	-015
AF	0.240	0.260		-250	-250	-250	-250	-250
AG	0.290	0.310		-300	-300	-300	-300	-300
AH	0.115	0.150		-138	-138	-138	-138	-138
AI	0.454	0.474		-464	-464	-464	-464	-464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		-250	-250	-250	-250	-250
AL	1.002	1.042		1.036	1.036	1.031	1.038	1.037
AM	0.053	0.073		-063	-063	-063	-063	-063
AN	0.257	0.262		-257	-257	-257	-257	-257
AO	1.663	1.683		1.672	1.673	1.673	1.673	1.673
AP	0.053	0.073		-063	-063	-063	-063	-063
AQ	0.022	0.042		-032	-032	-032	-032	-032
AR								
AS								
AT								
Accept/Reject								

Measured by:	JL	DAS	Date:	16-5-8
Audited by:	20	16-05-04	Date:	
Preliminary Approval:		9-89	Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	145015
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.188	0.193		-189	-189	-189	-189	-189
AB	0.240	0.260		-255	-255	-253	-253	-250
AC	0.115	0.150		-125	-125	-125	-125	-125
AD	0.040	0.060		-050	-050	-052	-052	-051
AE	0.010	0.020		-015	-015	-015	-015	-015
AF	0.240	0.260		-250	-250	-250	-250	-250
AG	0.290	0.310		-300	-300	-300	-300	-300
AH	0.115	0.150		-138	-138	-138	-138	-138
AI	0.454	0.474		-465	-465	-464	-464	-464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		-250	-250	-250	-250	-250
AL	1.002	1.042		1.034	1.038	1.036	1.036	1.034
AM	0.053	0.073		-063	-063	-063	-063	-063
AN	0.257	0.262		-257	-257	-257	-257	-257
AO	1.663	1.683		1.676	1.676	1.678	1.678	1.678
AP	0.053	0.073		-063	-063	-063	-063	-063
AQ	0.022	0.042		-032	-032	-032	-032	-032
AR								
AS								
AT								
Accept/Reject								

Measured by:	JL	Date:	16-5-3
Audited by:	DAS 20 116-05-04 9-89	Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	145015
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.252	.251	.251	.251	.251
AC	0.115	0.150		.125	.125	.125	.125	.125
AD	0.040	0.060		-.051	-.051	-.051	-.051	-.051
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.300	.300	.300	.300	.300
AH	0.115	0.150		.138	.138	.138	.138	.138
AI	0.454	0.474		.464	.465	.465	.464	.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.036	1.037	1.039	1.037	1.039
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.257	.257	.257	.257	.257
AO	1.663	1.683		1.678	1.678	1.678	1.677	1.677
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by:	SK	DAS	Date:	16-5-9
Audited by:	20	9-89	Date:	16-05-04
Preliminary Approval:			Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	